

split
Work Order ID 54900-2

January 5, 2010 8:39:25 AM



Page 1

Item ID: D205-708-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Adjustable Engine Mount

Start Date: 05/01/2010 Start Qty: 4.00

Required Date: 18/01/2010 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan: RL

Date: 10-1-05

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B80701

Rev C

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

0.00

8/10/05/19

0.00

110



Purchasing

Purchasing

PURCHASING

Memo

0.00

Issue P/O: 11023 for:

6	D3284-001	(B80702-1)	Sleeve
2	D3284-003	(B80703-1)	Stud
4	D3284-005	(B80704-1)	Stud
6	D3284-007	(B80705-1)	Stud
6	NAS509-12	Nut	
6	NAS509L12	NutStud	

To be assembled as per Dwg B80701 Rev. C
Possible Supplier: Northern Aero
Certificate of Conformity is required

CZ 1010105 (4)

Work Order ID 54900

January 5, 2010 8:39:25 AM



Item ID: D205-708-011

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Start Date: 05/01/2010 Start Qty: 4.00

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Receive & Inspect For Transit Damage Ensure Certificate of Conformity is attached

~~ASSEMBLY SET D205-708-011~~

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect assembly. Visually inspect thread, fit and cad plating

Pick Kit →

Subs/12

10-3-19

SL

73

130.1

140



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Subs/12

Memo

0.00

73

Work Order ID 54900

January 5, 2010 8:39:25 AM

Page 3

Item ID: D205-708-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Adjustable Engine Mount

Start Date: 05/01/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 18/01/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-708-011								
	Location: <u>21</u>								
	PPP Rev: <u>A</u>								
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10-3-19 SP 34

10/03/24

Picklist Print

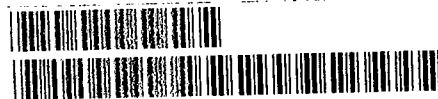
January 5, 2010 8:39:29 AM

Page 1

Work Order ID: 54900

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount



Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	La Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3284-001		Manufactured	No			140	Each	4.0000	24.0000			



Sleeve

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43644

4

4

140

Each

6.0000

8.0000



54900

10.01.18

D3284-003

Manufactured No



Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32724

35656

6

4

2

140

Each

6.0000

16.0000



54900

10.01.18

D3284-005

Manufactured No



Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

39942

43645

6

2

4

54900

10.01.18

Picklist Print

January 5, 2010 8:39:29 AM

Work Order ID: 54900

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3284-007 Stud		Manufactured	No			140	Each	4.0000	24.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>43646</div>												
<div>Loc Qty</div> <div>4</div> <div>4</div>												
<div>Loc Code</div> <div></div>												
D3284-009 Bearing		Manufactured	No			140	Each	3.0000	24.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>44781</div> <div>48118</div>												
<div>Loc Qty</div> <div>3</div> <div>1</div> <div>2</div>												
<div>Loc Code</div> <div></div>												
D3284-011 Bearing		Manufactured	No			140	Each	4.0000	4.0000			
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>44782</div>												
<div>Loc Qty</div> <div>4</div> <div>4</div>												
<div>Loc Code</div> <div></div>												

B55427 16 W
55437 1 W 10.01.18

B54997 17x 10-3-1550
B57004 1x 10-3-1850

10-3-1550 30

3

January 5, 2010 8:39:29 AM

Shop Packet Print

Picklist-Print

January 5, 2010 8:39:30 AM

Work Order ID: 54900

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20613-6C12		Purchased	No			140	Each	106.0000	8.0000			

5.13 
RIVET

10-3-15 SP

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	106	
	100089	14	
	105433	92	

5.13 
Rivet

Purchased No

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	11	
	104260	7	
	19513	4	

24X 10-3-15 SP
M112511 ~~34900~~

5.13 
Rivet

Purchased No

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	96	
	19513	96	

10-3-15 SP (3X)

January 5, 2010 8:39:30 AM

Shop Packet Print

Picklist Print

January 5, 2010 8:39:30 AM

Work Order ID: 54900

Parent Item: D205-708-011

Parent Item Name: Adjustable Engine Mount

Comments:

Start Date: 05/01/2010

Required Date: 18/01/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Rate Seq	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20613-6C19		Purchased	No			140	Each	77.0000	48.0000			

S
B



Rivet

10-3-15

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

77

106375

77

140

Each

43.0000

24.0000

3/2

NAS509-12

Purchased

No



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

43

15057

43

140

Each

38.0000

24.0000

84906

u

NAS509L12

Purchased

No



Nut

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

38

102296

29

15062

8

35656

1

54900

u

January 5, 2010 8:39:30 AM

Shop Packet Print



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3284	REV. A SHEET 1 OF 1
DATE 04.05.06		TITLE ADJUSTABLE ENGINE MOUNT SCALE 1:1	
A	04.05.06	NEW ISSUE	

RELEASED
04.05.17

SPECIFICATION CONTROL DRAWING

DART P/N	SPECIFICATION
D3284-001 SLEEVE	ACS P/N B80702-1 PER ACS DWG B80702 REV. A
D3284-003 STUD	ACS P/N B80703-1 PER ACS DWG B80703 REV. A
D3284-005 STUD	ACS P/N B80704-1 PER ACS DWG B80704 REV. A
D3284-007 STUD	ACS P/N B80705-1 PER ACS DWG B80705 REV. B
D3284-009 BEARING	BHT P/N 47-140-252-5
D3284-011 BEARING	BHT P/N 205-060-101-001
D3284-021 TUBE ASSY	204-060-158-001 MODIFIED PER IIN-D205-708
D3284-023 BIPOD ASSY	204-060-155-001 MODIFIED PER IIN-D205-708
D3284-025 TRIPOD ASSY	204-060-157-001 MODIFIED PER IIN-D205-708
D3284-031 TUBE ASSY	205-060-107-001 MODIFIED PER IIN-D205-708
D3284-033 BIPOD ASSY	205-060-106-001 MODIFIED PER IIN-D205-708
D3284-035 TRIPOD ASSY	205-060-105-001 MODIFIED PER IIN-D205-708

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54900

BP10-1-05

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ACS-NAI Ltd.

25 Dunlop Avenue
R2X 2V2 Winnipeg
Canada
Tel : 204-772-9922
Fax : 204-772-7568

Delivery No. : 622
Delivery Date : 01/07/2010
SO No. : 22391
Your Reference : PO: PO11023
Delivery Method : FED EX 2351 4353 4
Payment Condition : Net 30 Days

Delivery to: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Item	Description Batch Number	Total Ordered	Unit	Qty Delivered	Delivery Date
B80702-1	SLEEVE 08-1874	24	EA	24	01/07/2010
B80703-1	7/8 STUD 07-2903	8	EA	8	01/07/2010
B80705-1	STUD 08-2459	24	EA	24	01/07/2010
B80704-1	3/4 STUD 08-1927	16	EA	16	01/07/2010
NAS509-12	NUT (.7500-16 UNJF-3B) 07-2750	24	EA	24	01/07/2010
NAS509-L12	NUT STEEL (.7500-16 UNJF-3B-LH) LH THREAD 08-1060	24	EA	24	01/07/2010

CURRENCY: US FUNDS
SHIP VIA: FEDEX ACCT# 151793240
ATTN: CHANTAL LAVOIE @ 613-632-9577

Packages: 0

Gross Weight: 0.00

Net Weight:

Ordered by: Dart Aerospace Ltd.

Attention: Chantal Lavoie
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Invoice to: Dart Aerospace Ltd.

0.00

Attention: Accounts
1270 Aberdeen Street

Hawkesbury K6A 1K7
Canada

Remarks**Certification Statement**

I hereby certify that the aircraft part(s) described hereon were
acquired from a source of supply that is consistent with the
conditions under which TCCA distributor approval AMO88-97
has been granted.

NAS509-12 (24)
NAS509-L12 (24)

Signatory

Date:

7 Jan 2010

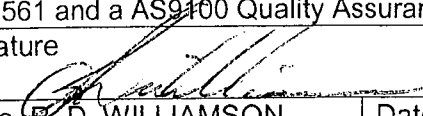
CERTIFICATE OF CONFORMITY

Form Tracking No. 22391-1		Work Order/Contract/Invoice PO: PO11023		Cage Code: MFR-L0555	
Item	Description	Part No.	Quantity	Serial/Batch	Status
1	Sleeve	B80702-1	24	08-1874	manufactured
2	Stud	B80703-1	8	07-2903	manufactured
3	Stud	B80705-1	24	08-2459	manufactured
4	Stud	B80704-1	16	08-1927	manufactured

Remarks:
THESE ITEMS CONFORM TO APPROVED DESIGN DATA B80702 (REV. A), B80703 (REV. A), B80704 (REV. A), AND B80705 (REV. B), AS APPLICABLE.

New-Unused Parts/Material Certification

The items described above have been manufactured using standards employed by a TCCA approved manufacturer in accordance with CAR 561 and a AS9100 Quality Assurance System.

Signature 

Name R. D. WILLIAMSON Date (dd mmm yyyy)
07-Jan-10

~~Used, Repaired or Overhauled Parts Certification~~

~~The items described above have been maintained using standards employed by a TCCA approved maintenance organization in accordance with CAR 573 and a AS9100 Quality Assurance System.~~

~~Signature~~

~~Name Date (dd mmm yyyy)~~

User/Installer Responsibilities: This certificate does not constitute authority to install the item(s) described above on an in-service type certified aircraft.

**DART Helicopter Services, L.L.C.**

1736 Ord Way
Oceanside, CA 92056
USA
Ph: 1-613-632-3336, Fax: 1-613-632-4443
sales@darths.com

Purchase Order

Order #: 5325
Prepared By: Nancy MacLeod
Date Printed: 1/12/2010
Time: 11:49:00 AM
of Items: 1
Page: 1

Purchased From:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ship To:

SUMMIT HELICOPTERS, INC. (CSUMM01)
SHIPPING: 595 COUGAR DRIVE
CLOVERDALE, VA 24077 USA
ATT: RICHARD DAY
Tax ID#: 54-1156923 Tel #: 1 540 591 5880

PO Date: 1/12/2010 Cust Ref#: 0010574
Need Date: 1/19/2010 Terms: NET 30
Remarks: GOOD TO GO NM 12JAN10

Vendor #: CDART02
Phone #: 1 613 632 3336
Resale: YES

Customer: SUMMIT HELICOPTERS, INC.
Fax #:
Resale #:

Insure?: Ship Via: UPS GROUND

Account: 297 041

DHSPEGGY

All items subject to our inspection and acceptance

Item	Part Number/Description	Delivery	To Ship	CD	List Price	Disc%	Unit Price	Total Amt
1	D205-708-011 Adjustable Engine Mount Installation SO#: 3369	1/19/2010	1.00	FN	\$5,543.10	23.00%	\$4,268.19 EA	\$4,268.19
Special pricing as approved by Bill Beckett of Dart Aerospace Ltd and DHS LLC.								

Item Total: \$4,268.19

Charges: \$0.00

Total: \$4,268.19

US Dollars

Authorized Signature:

L Lacelle

From: Al Wilson [AWilson@acs-nai.com]

Sent: January 12, 2010 2:50 PM

To: 'llacelle@dartaero.com'

Cc: 'Jason Murdoch'

Subject: PO11023

Hello Jason and Linda as per our conversation earlier in the day.

The inhibitor has been applied to the B80705-1 studs and the B80702-1 Sleeves during the assembly of the parts referenced in PO11023.

Thanks

Al

1/12/10

Work Order ID 54900

January 5, 2010 8:39:25 AM

Page 1

Item ID: D205-708-011

Accept

Revision ID:

Item Name: Adjustable Engine Mount

Start Date: 05/01/2010 Start Qty: 4.00

Required Date: 18/01/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: *RP*

QC:

Date: *10-1-05* Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

B80701

Rev C

100

0.00



DOCUMENT CONTROL *SC*

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-708-011, CHG001

110

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *11023* for:

6	D3284-001	(B80702-1)	Sleeve
2	D3284-003	(B80703-1)	Stud
4	D3284-005	(B80704-1)	Stud
6	D3284-007	(B80705-1)	Stud
6	NAS509-12	Nut	
6	NAS509L12	NutStud	

To be assembled as per Dwg B80701 Rev. C
Possible Supplier: Northan Aero
Certificate of Conformity is required

PL 10-3-15

CL 1010105 (4)